Work Order ID 51103 August 4, 2009 11:03:30 AM Item ID: D2617-3 Accept Setup Start **Revision ID:** D2 Stop Item Name: Bushing **Start Date:** 8/31/09 Start Qty: 40.00 **Cust Item ID:** Required Date: 8/31/09 Req'd Qty: 40.00 **Customer:** Reference: Run Start Date: 09-08-0 Process Plan: Tooling: Approvals: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Reject Set Up/ Draw Draw Plan Accept Reject **Work Center ID** Description Qty Qty Number Rev. Code **Run Hours** Draw Nbr **Revision Nbr** Rev D2 D2617 100 Hardinge CNC LATHE SMALL 0.00 Hardinge Memo Hardinge CNC Lathe Small Turn as per Folio FA437 and Dwg D2617 C .

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

QC8- Inspect parts - second check

Page 1



Insp.

Number Stamp

120

QC

Quality Control

Memo

0.00

0.00

0.00

0.00 \$ 10968/06

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W/O:			W	ORK ORDER CHANG				٠,	
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
,				· .					
		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
	Res	solution:	Dispositio	on:	_ QA: N/C C	losed:		Date: _	
NCR:		V	WORK ORD	ER NON-CONFORMA	NCE (NC	R)		M	
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Verific		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector
							•		

Work Order ID 51103

August 4, 2009 11:03:30 AM



Page 2

Item ID:

D2617-3

D2

Accept

Setup Start



Revision ID:

Bushing Item Name:

Required Date: 8/31/09

Start Date:

8/31/09

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop

Stop

Sequence ID/

Work Center ID

130

Small Fab

Small Fab

Operation Description Set Up/

Run Hours

Draw Number

Draw Plan Rev. Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

Small Fab

Memo

0.00

Deburr break all unmarked sharp edges 0.005 to 0.010

Date:

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

Memo

Bl 09-08-7.

~0908/0K

150

QC5- Inspect part completeness to step on W/O

PO-30-50 /A 02-08-09



Quality Control

Dart Aerospace Ltd

									±-
W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Re	solution:						Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCR)	•		
DATE	STEP	Description of NC	In it is a	ction B	- Verification			Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section	on C	Chief Eng	QC Inspector
	1								
		_							
			·						

Work Order ID 51103

Page 3

August 4, 2009 11:03:30 AM

Item ID:

D2617-3

D2

Revision ID: Item Name:

Bushing

Start Date: Required Date: 8/31/09

8/31/09

Start Oty: 40.00

Req'd Oty: 40.00



Accept

Setup Start

Stop

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop



Sequence ID/ Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:



Memo

Set Up/ **Run Hours**

0.00

0.00

Draw Number Draw Rev.

Plan Code Oty

Reject Accept **Qty**

Rıın

Reject

Insp. Number Stamp

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF 09-08-08

Dart Aerospace Ltd

- 411710	ospace	Liu							,
W/O:			WC	RK ORDER CHAN	GES				
DATE	STEP	PR	OCEDURE CHAI	OCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							;		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
			Disposition: Q						
NCR:			WORK ORDE	ER NON-CONFORM	IANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verificati		on Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
						·	i		

August 4, 2009 11:03:29 AM

Work Order ID: 51103

Parent Item:

D2617-3RevD2

Parent Item Name: Bushing

Comments:



Start Date: 8/31/09

Required Date: 8/31/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M6061T6T0.375W.058		Purchased	No			100	f	169.6200	3.0695			

6061-T6 RD Tube .375 x.058W

<u>Warehouse</u>	Loc Oty	Loc Code	
Location			- :
Main Warehouse			
, MAT	169.62		
110485	9.67		
110968	3.67	_	
111432	36.28		MF 09-08-11
111944	120		,

Dart Aerospace	Ltd
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W/O:			WC	RK ORDER CHANG	GES.					
			-	THE OHDER OHAIR	GLU					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·							
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes N	10 DQ	A:	Date:	
		olution:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR))			
DATE	STEP	Description of NC	Corrective Action Section B			Verific		cation Approval	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
					-					





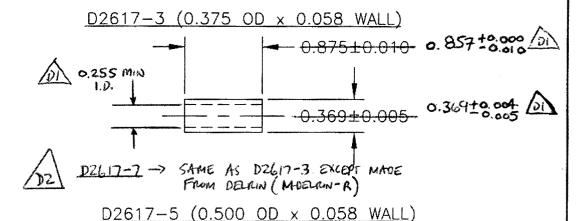
DESIGN	BW	DRAWN BY		EROSPACE LTD JURY, ONTARIO, CANADA
CHECKE	#	APPROVED	DRAWING NO.	REV. D SHEET 1 OF 1
DATE			TITLE	SCALE
01.0	7.04		BUSHING	
Α		96 10 08	NEW ISSUE	

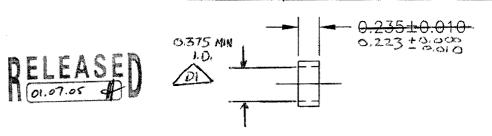
DZ 04.09, 10 # (A) ADD D2617-7

D2617-1 (0.375 OD x 0.058 WALL)

Α	96.10.08	NEW ISSUE
В	97.05.08	.875 WAS 1.125
С	97.06.04	0.369 DIA WAS 0.375
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
DI	9-1 04,57.12	CORRECT TOLERANCE (NCR 774)

1.875±0.010





NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
 - OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	51103
Description: Bushing	Part Number:	D2617-3
Inspection Dwg: D2617 Rev: D2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototyp	е
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Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+0.000/-0.010	,852				
+0.004/-0.005	.370				
	, .				
	+0.000/-0.010	Tolerance +0.000/-0.010 +0.004/-0.005 -370	Tolerance Dimension Accept +0.000/-0.010	Tolerance Dimension Accept Reject +0.000/-0.010 , \$52	Tolerance Dimension Accept Reject Inspection

Measured by:	Audited by:	Prototype Approval:	N/A
Date: Chickork	Date: 09/08/07	Date:	N/A

ſ	Rev	Date	Change	Revised by	Approved
ŀ	A	04.08.09	New Issue	KJ/JLM	1
ŀ	R	06.03.08	Dwg Rev change	KJ/JLM	
l		00.00.00	Dig ito onange	, ()	7,07